

Work Order ID 62707

Wednesday, October 06, 2010 3:21:21 PM

Page 1

Item ID: D3535-15

Accept

Revision ID:

Item Name: Wearshoe

Start Date: 10/6/2010 Start Qty: 8.00

Required Date: 10/15/2010 Req'd Qty: 8.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3535

Rev B

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

304 . 410

B10-10-14

(13)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B10-10-14

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

S 10/10/14

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

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Accept

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Item Name: Wearshoe

Start Date: 10/6/2010 Start Qty: 8.00

Required Date: 10/15/2010 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

JD

10/10/19

13

Ø

170



Packaging

Packaging

Identify as per dwg & Stock Location: F25

Memo

0.00

0.00

JM

10/10/19

13

Ø

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/10/2010

MF

10-10-19

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, October 06, 2010 3:21:25 PM

Page 1

Work Order ID: 62707

Parent Item: D3535-15

Parent Item Name: Wearshoe




Start Date: 10/6/2010

Required Date: 10/15/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	108.6987	1.0205	8.593684		13-3 1810-10-14	

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT

85.9522

114574

10.6522

115762

75.3

MAT20

22.7465

112885

2.7475

113062

0.699

115440

19.3

115762

13

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DART AEROSPACE LTD		Work Order:	62707
Description: Wearshoe		Part Number:	D3535-15
Inspection Dwg: D3535	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.886	*		V 1B02	
2.000	+/-0.010	2.000	*		V	
5.650	+/-0.010	5.656	*		T 1B01	
9.150	+/-0.010	9.150	*		T	
14.400	+/-0.010	14.400	*		T	
19.650	+/-0.010	19.650	*		T	
24.900	+/-0.010	24.900	*		T	
30.150	+/-0.010	30.150	*		T	
33.650	+/-0.010	33.650	*		T	
35.650	+/-0.010	35.650	*		T	
39.150	+/-0.010	39.150	*		T	
Ø0.188	+0.005/-0.001	-1.92	*		V	
24.00	+/-0.030	24.06	*		T	
16.00	+/-0.030	16.00	*		T	
8.00	+/-0.030	8.00	*		T	
5.00	+/-0.030	5.00	*		V	
0.300	+/-0.010	305	*		V	
0.300	+/-0.010	305	*		V	
0.038	+/-0.010	1037	*		V	

Measured by:	B
Date:	10-10-14

Audited by:	S
Date:	10/10/14

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	BE

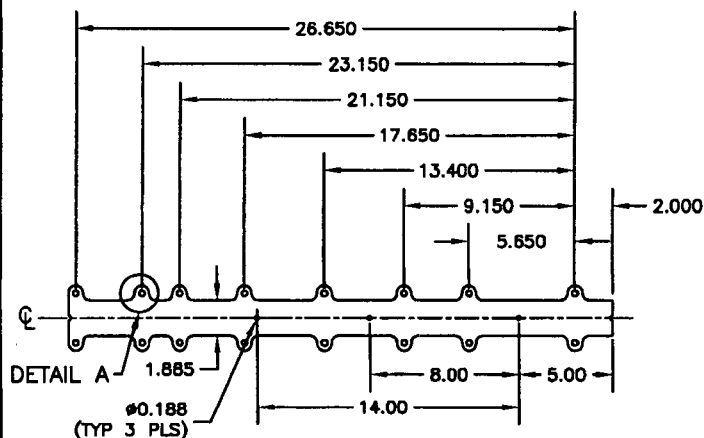
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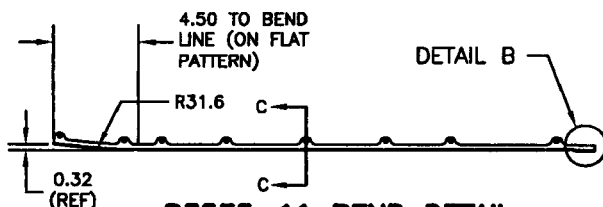
07.04.24

SHOP COPY
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ENGINEER
UNCONTROLLED COPY
SUBJECT TO A CHANGE OF
WITHIN THE
WORK ORDER
NO. 62207

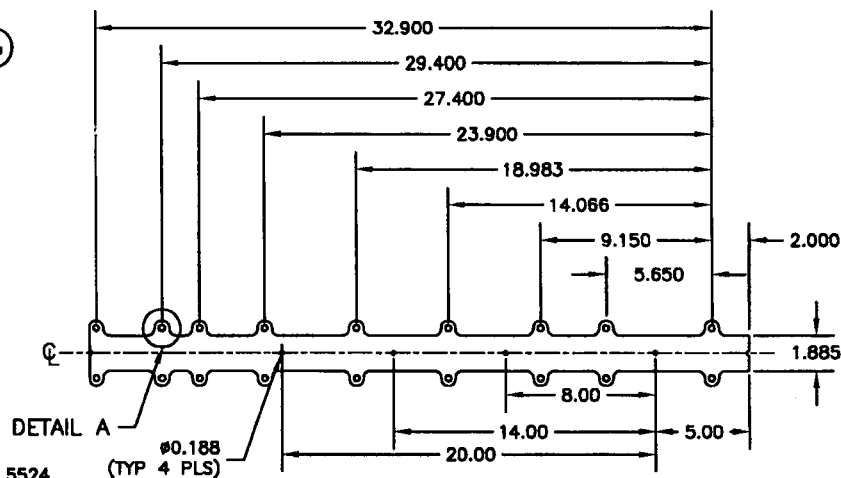
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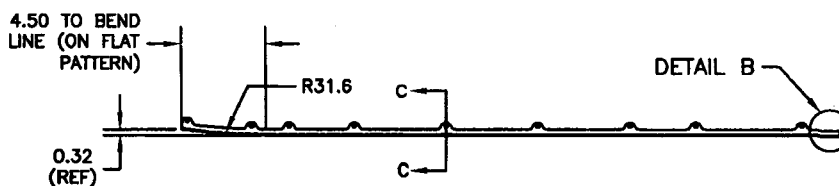
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 1 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

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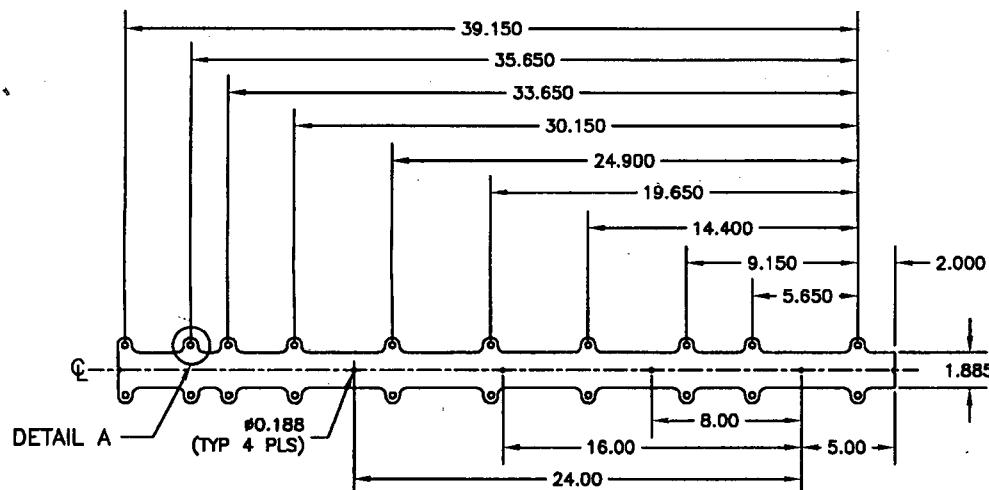
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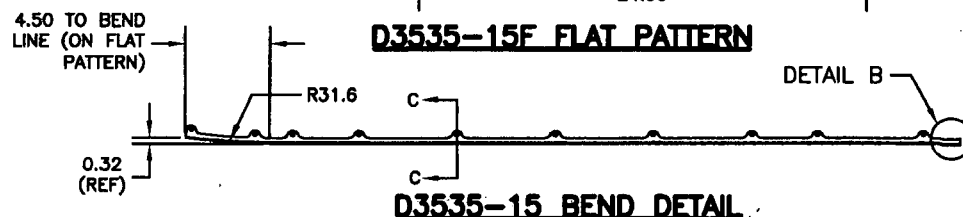
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W/042707

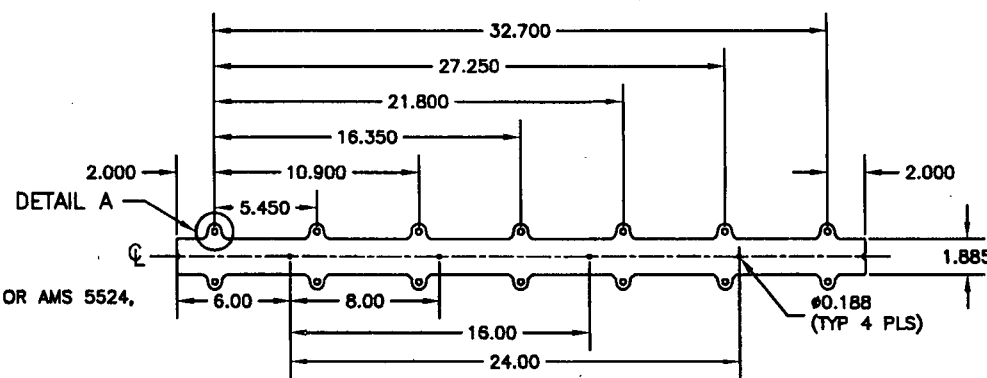
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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 2 OF 7
DATE	TITLE		SCALE
07.04.17	WEARSHOE		1:10



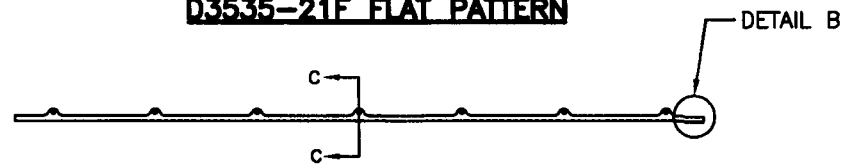
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

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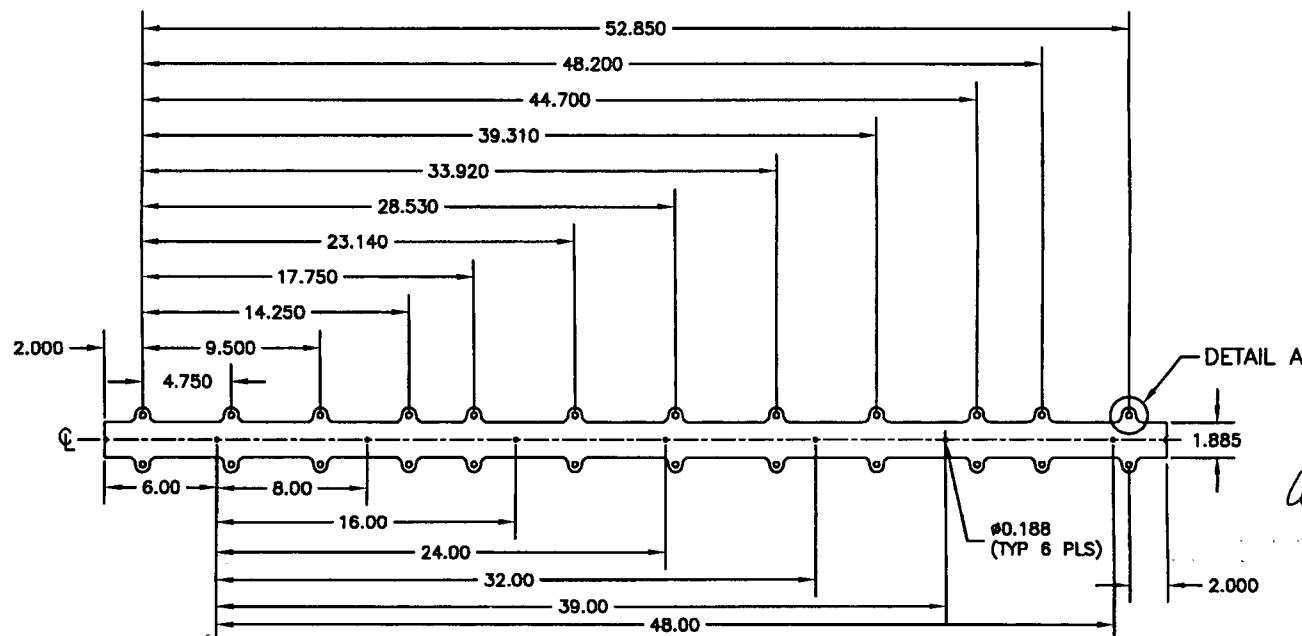
NOTE: Date & initial all entries

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07.04.24

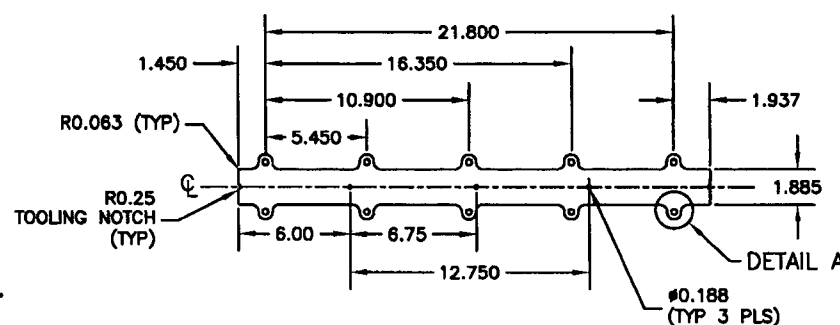
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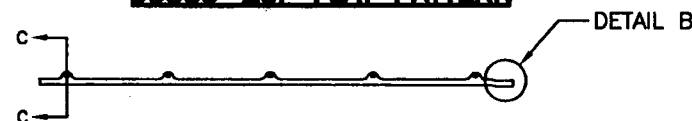
D3535-23F FLAT PATTERN



D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 3 OF 7
		SCALE
		1:10

W/O:		WORK ORDER CHANGES					
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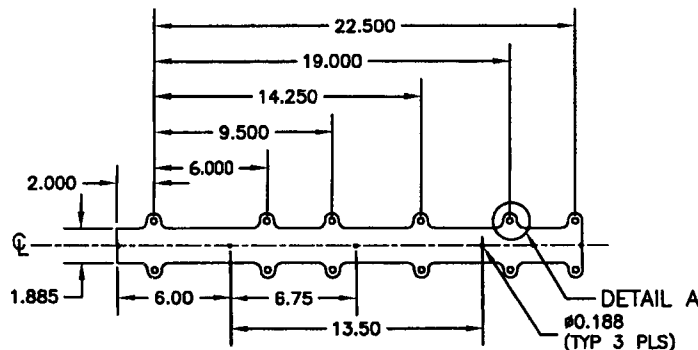
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07.04.24

WLO 62707

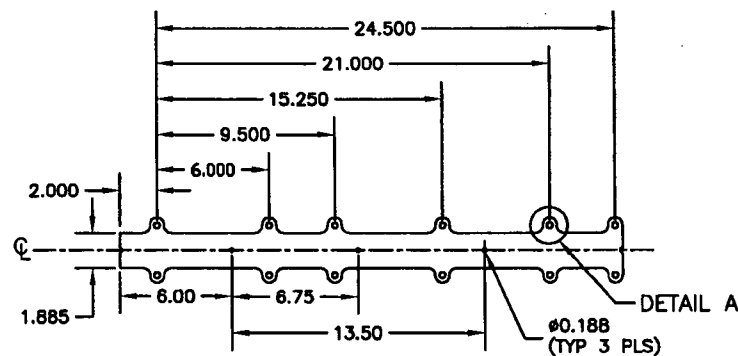
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
TITLE	WEARSHOE	SHEET	4 OF 7	SCALE



D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

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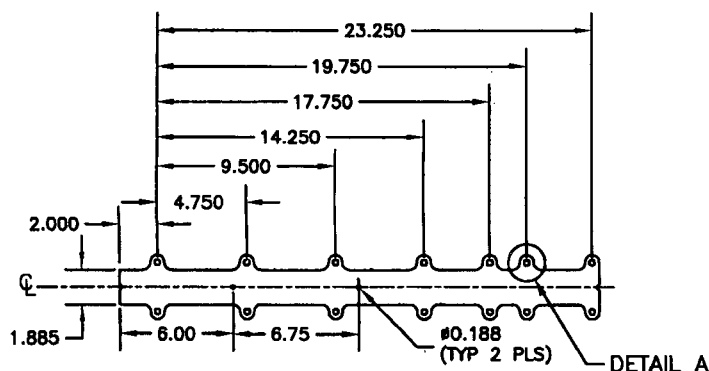
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WLO 62707

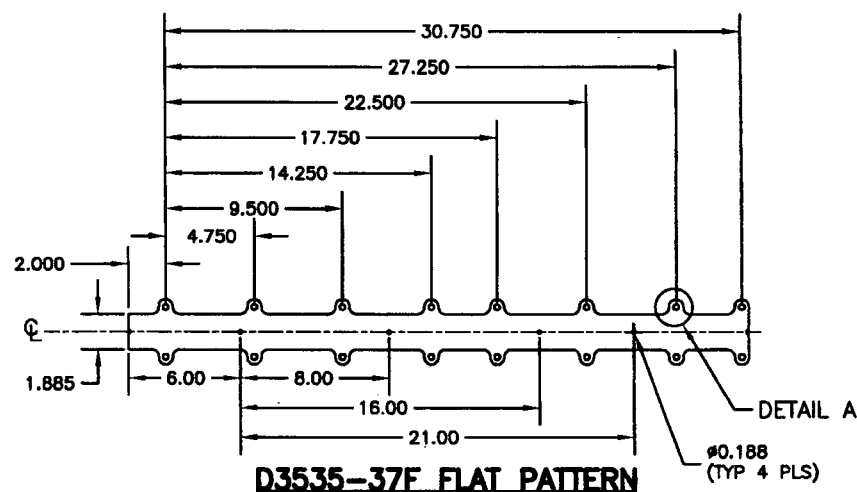
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
		SCALE	1:10	



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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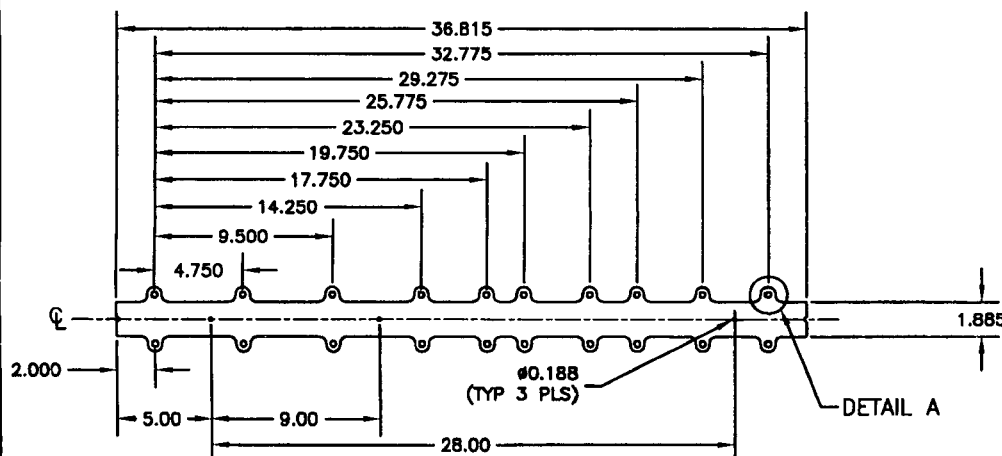
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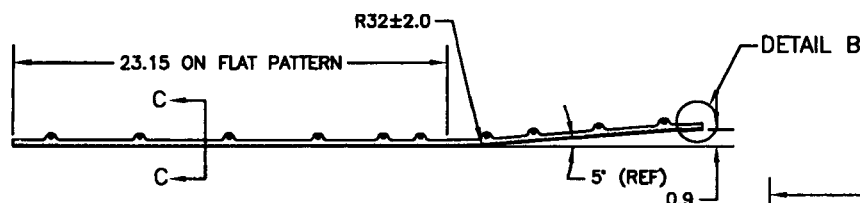
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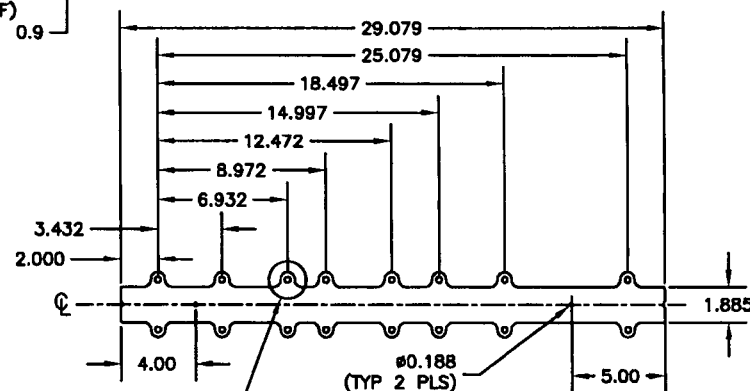
DESIGN	C.B.	DRAWN BY	M.H.	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
				REV. B
				SHEET 6 OF 7
				SCALE 1:10



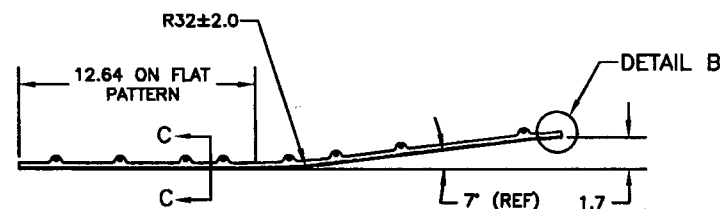
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

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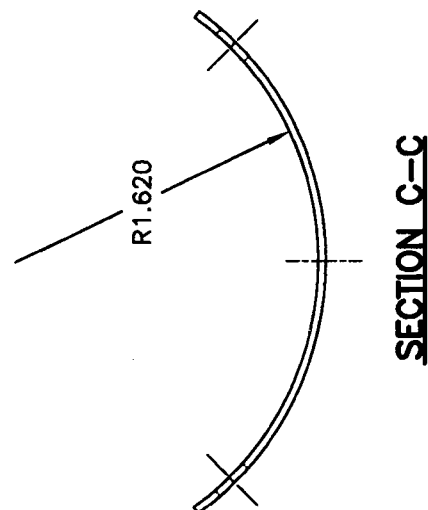
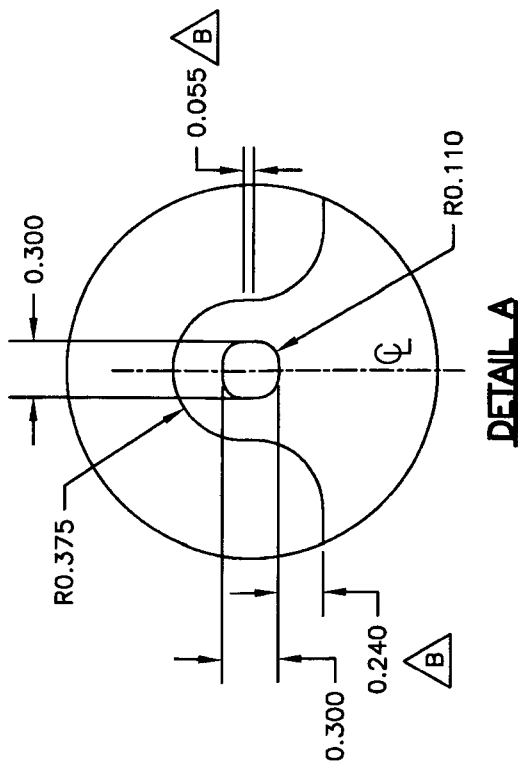
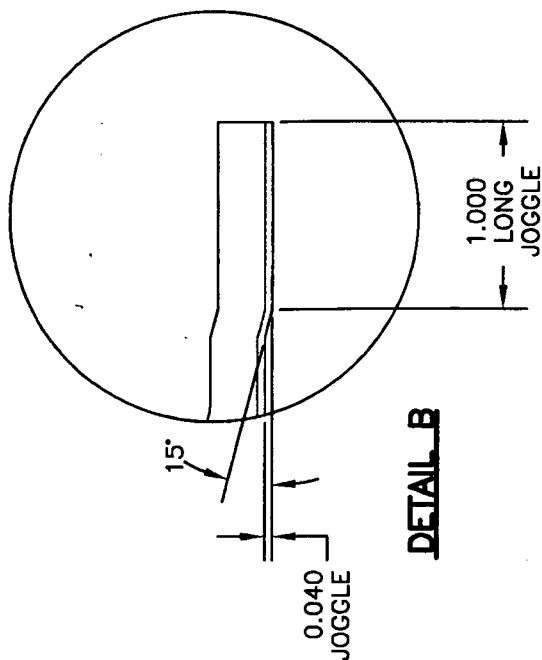


DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

RELEASED

07.04.24

w/o 42707



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